

**Work Order ID 59640**

Wednesday, June 09, 2010 9:46:23 AM



Page 1

Item ID: D3572-3

Accept



Setup Start



Revision ID:

Item Name: Guide

Stop



Start Date: 6/9/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 6/24/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10-6-09

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3572	Rev D

100



BAND SAW

0.00

J.A 10/06/11

20 φ

Bandsaw

Jeaspa Bandsaw

Memo

0.00

Cut blank .500" long

110



HAAS CNC VERTICAL MACHINING #1

0.00

J.A 10-6-14

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

1- Mill as per Folio FA685 Rev: J.A & Dwg D3572 Rev: 2- Deburr  
per dwg D3572

120



QC2- Inspect parts off machine FAI/FAIB

0.00

J.A 10-6-14

QC

Quality Control

0.00

20

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

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Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

Tool ID

JL

Tool #

10/06/14

Plan  
Code

10/06/14

Accept  
Qty

0

Reject  
Qty

0

Reject  
Number

0

Reject  
Number

0

Insp.  
Stamp

10/06/14

140



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 244

0.00

X20 33 10/06/14

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/15 JF

MF

10-6-14

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NOTE: Date & initial all entries

# Picklist Print

Wednesday, June 09, 2010 9:46:26 AM

Page 1

Work Order ID: 59640



Parent Item: D3572-3



Parent Item Name: Guide

Start Date: 6/9/2010

Required Date: 6/24/2010

Comments: IPP Rev:A New Issue 07-02-07 JLM  
IPP rev B rev.B dwg EC

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0			No				f	4.8010	0.04	0.800400			



6061-T6 Bar .750 X 1.50

Location	Loc Qty	Loc Code
MAT	4.801	
114415	4.801	

0.8004 ft 6.A 10/06/11

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DART AEROSPACE LTD	Work Order:	58440
Description: Guide	Part Number:	D3572-3
Inspection Dwg: D3572	Rev: D	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by: <i>mf</i>	Audited by: <i>SL</i>	Prototype Approval:	N/A
Date: <i>10.6.14</i>	Date: <i>10/06/14</i>		Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.04.15	Dimensions updated per Dwg Rev. C	KJ/DD	
C	09.05.15	Dwg Rev updated	KJ	

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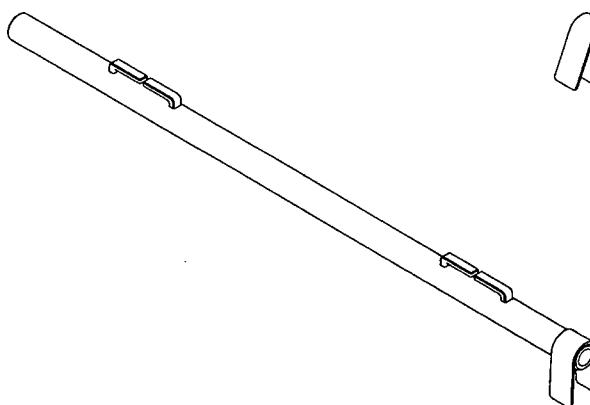
NOTE: Date & initial all entries

ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3		X		D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

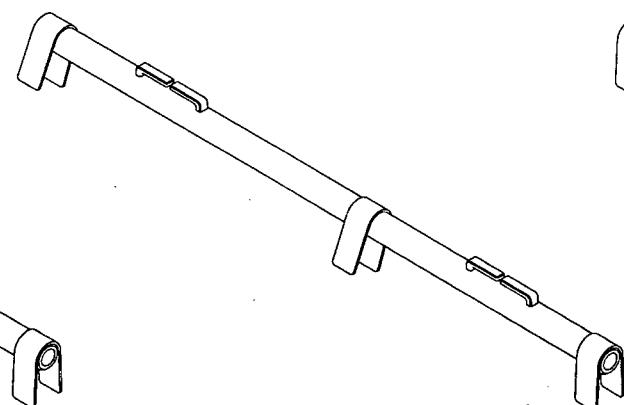
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 59640  
2810-6-09

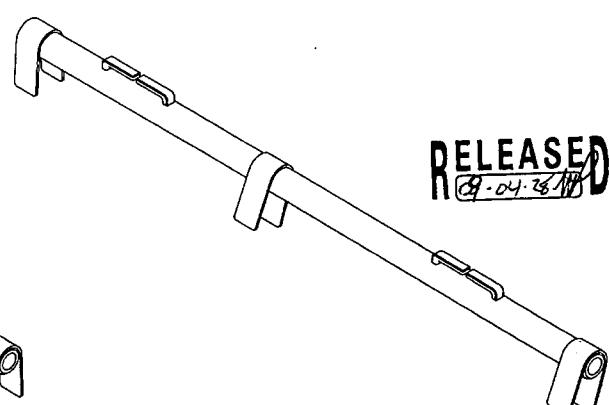
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09-04-16



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



D3572-044 GUIDE ASSEMBLY (UH-1)

NOTES:  
 1) MATERIAL: NONE  
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT -041: 1.34 lbs  
 -043/-044: 1.42 lbs  
 8) WELDING: PER DART QSI 004

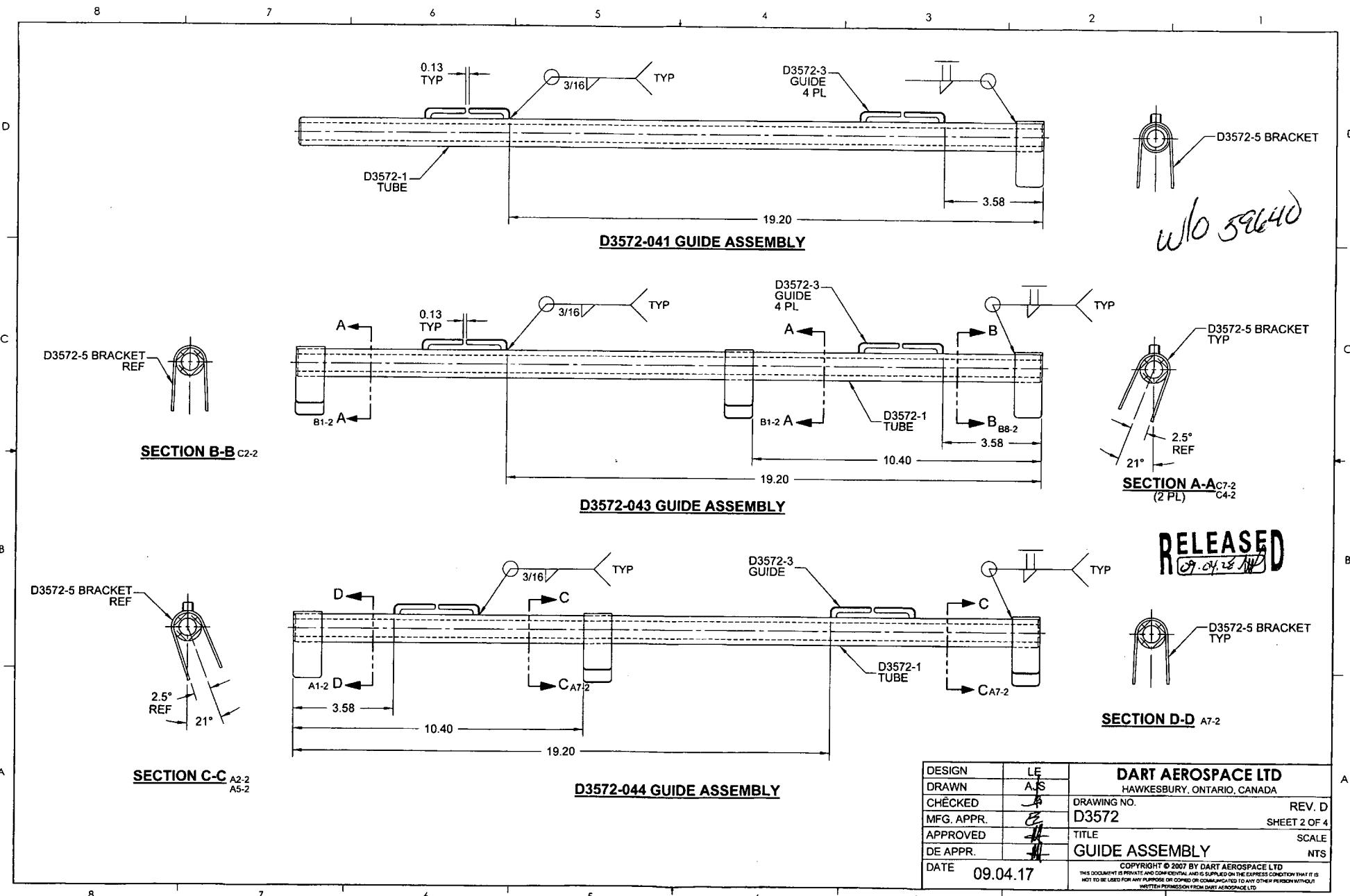
D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.		AJS	09.04.17
C	REMOVE D3572-7		LE	07.06.01
B	FOR D3572-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET		LE	07.04.20
A	NEW ISSUE		LE	07.03.29
REV.	DESCRIPTION		BY	DATE
	DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AJS		
	CHECKED	AS	DRAWING NO.	REV. D
	MFG. APPR.	CE	D3572	SHEET 1 OF 4
	APPROVED	CE	TITLE	SCALE
	DE APPR.	CE	GUIDE ASSEMBLY	NTS
	DATE	09.04.17	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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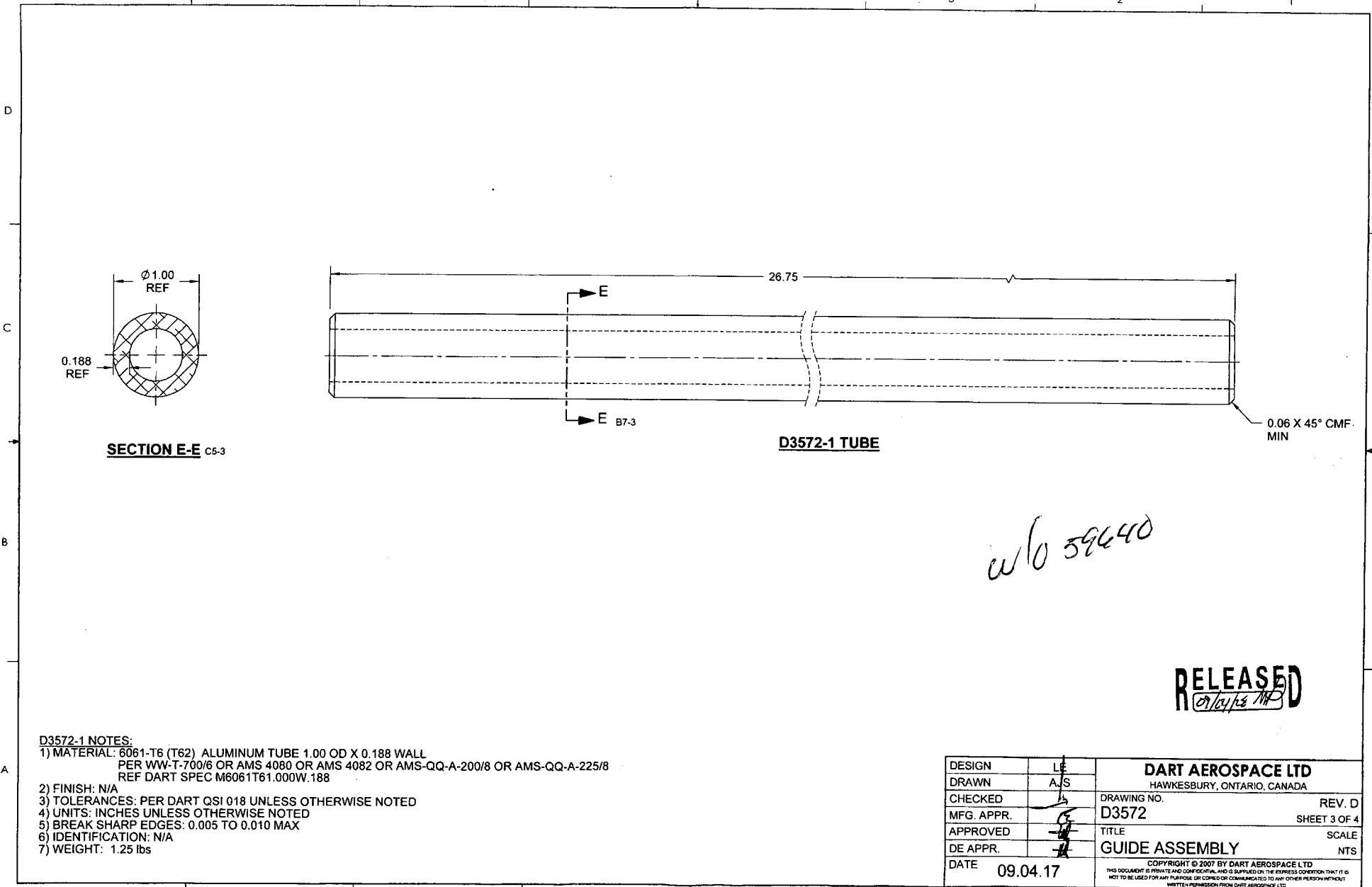
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8 7 6 5 4 3 2 1



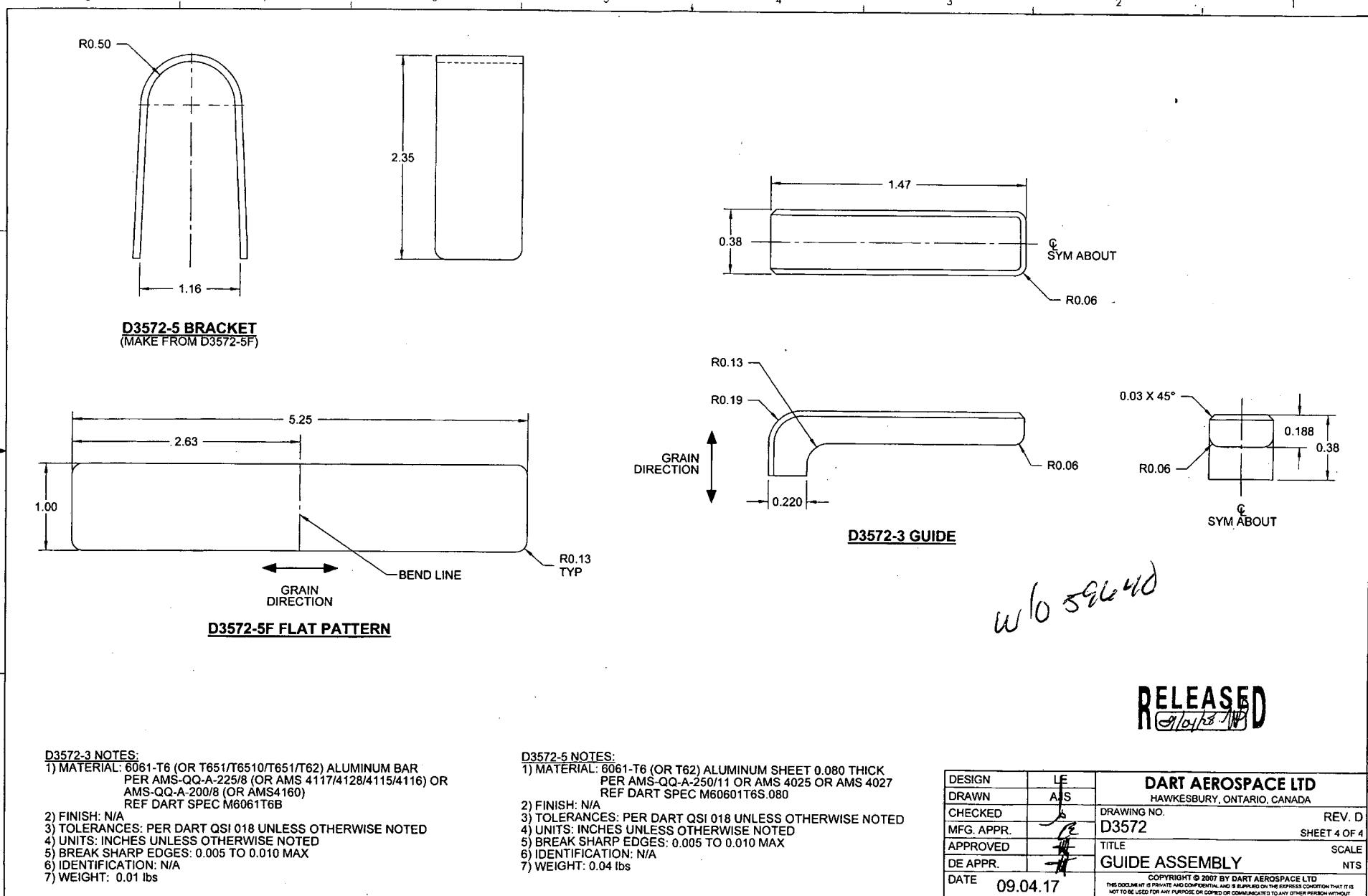
8 7 6 5 4 3 2 1

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W/10 5/6/10

RELEASED  
9/04/17

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